

5/13  
DART AEROSPACE LTD

Work Order:

22516

Description: Bracket Assembly

Part Number:

D2804-042

Dwg: D2804 Rev. B

Qty:

15 20





Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler <b>Dwg not required</b>	HA	05.02.23	20																				
2	GA	Press D2805-2 into arm as per Dwg D2804 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2804-2</td><td>Bracket</td><td>B22526 B</td></tr><tr><td>1</td><td>D2805-2</td><td>Stop</td><td>B22527</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>B22529</td></tr></table>	Qty	Part Number	Description	Batch	1	D2804-2	Bracket	B22526 B	1	D2805-2	Stop	B22527	1	D2809	Bushing	B22529	SB	05/03/23	20				
Qty	Part Number	Description	Batch																						
1	D2804-2	Bracket	B22526 B																						
1	D2805-2	Stop	B22527																						
1	D2809	Bushing	B22529																						
3	QC5	Inspect work to Step 2	HA	05.03.23	20																				
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	SG	05/03/24	20																				
5	QC3	Inspect Powder Coat	HA	05.03.24	20																				
6	GA	Press D2809 into arm as per Dwg D2804	SB	05/03/28	15																				
7	GA	Spray LPS-3 on Bolt Shaft, <b>not</b> on thread as per Dwg D2804 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt</td><td>M17046</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M16947</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td>M16947</td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td>M16863</td></tr></table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt	M17046	2	MS21042L3	Nut (or -3)	M16947	4	NAS1515H3	Washer	M16947	A/R	LPS-3	Corrosion Spray	M16863	SB	05/03/28	15
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt	M17046																						
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4	NAS1515H3	Washer	M16947																						
A/R	LPS-3	Corrosion Spray	M16863																						
8	GA	Assemble as per Dwg D2804.	SB	05/03/29	20																				
9	QC5	Inspect work to Step 8	Z	05.03.29	15																				
10	ST	Identify and Stock	CL	05/04/14	15																				
11	AC	Cost / part: 64.78	SAE	05-04-19	15																				
12	DC	Close W/O 63.3, Inspect Level 21	HA	05.04.20	15																				

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	

RELEASED  
11/15/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22516		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-03-31	7	D2808 & D2809 were stored in boxes under wrong # Here some wrong bushing was installed in brackets	 05-03-31	remove bushings and press fit proper bushing	SB 05/03/31	 05-03-31	 05-03-31	 05-03-31
05-03-31	4	Too much paint See NCR 840						

Part No: D2804-042

PAR #: \_\_\_\_\_

Fault Category: Prod / FMB' 035'

Med-Small

NCR: Yes No

DQA: 

Date: 05/04/20

NOTE: Date &amp; initial all entries

QA: N/C Closed: 

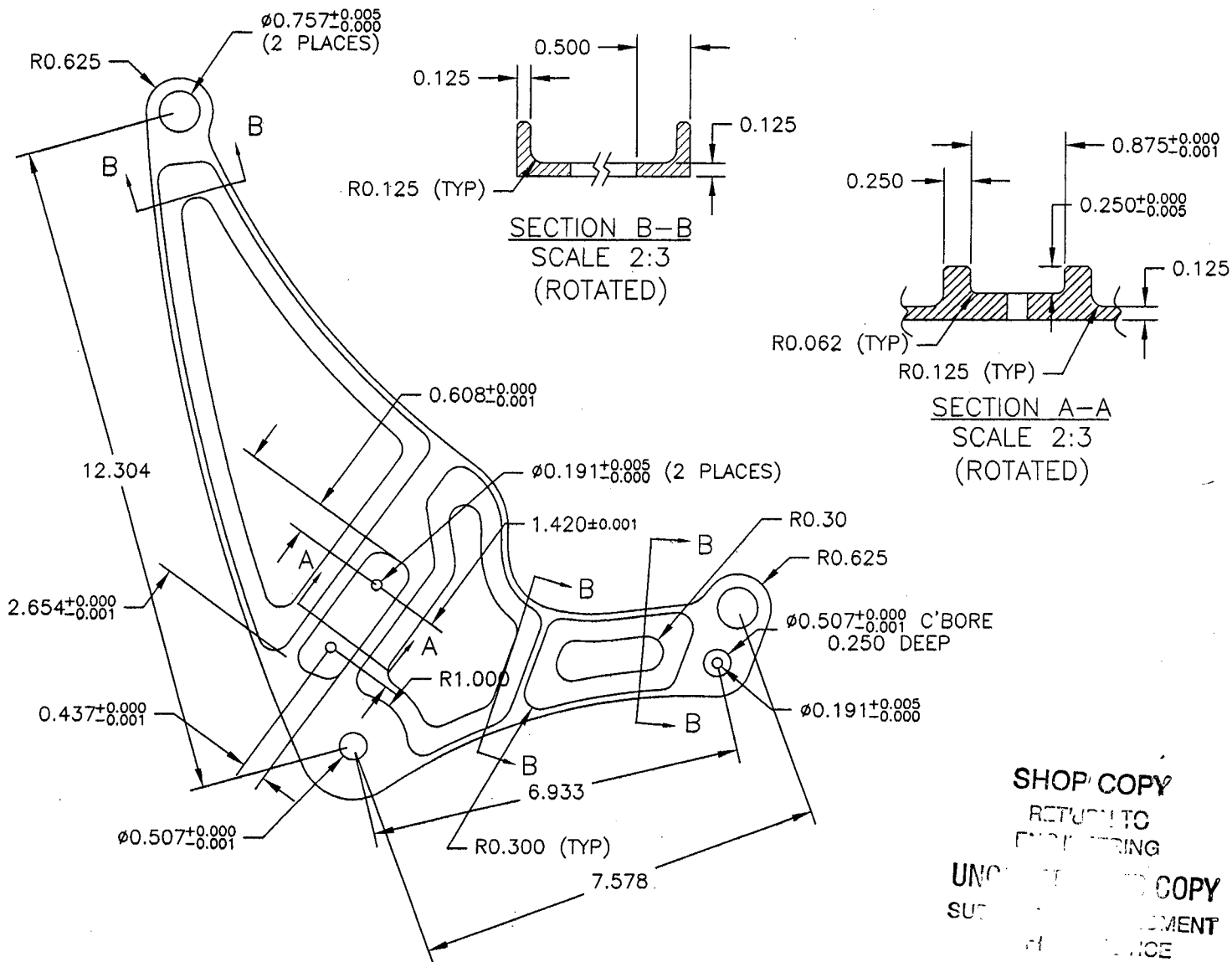
Date: 05.04.20



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05-03-11



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WORK ORDER

NO. ZZ516

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

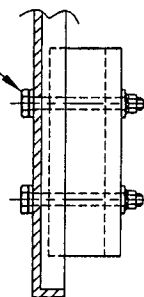
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3

AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



SECTION C-C  
SCALE 1:3  
(ROTATED)

USE D2804-1 FOR D2804-041/-043  
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041  
USE D2805-2 FOR D2804-042  
USE D2805-3 FOR D2804-043  
USE D2805-4 FOR D2804-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO  
POWDER COAT

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WITHOUT NOTICE

WORK ORDER

NO. 22516  
RELEASED

05-03-11 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN).  
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 22, 2005  
03:39 pm

Work Order No : 0022516  
Project Name : D2804-042  
Project For : WK513  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2804-042  
Description : Bracket Assembly  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 02-22-05  
Est Finish Date : 03-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00